### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: <u>69.28</u>

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary Report No: WIR-004743

Address: 333 Burma Road Date Inspected: 21-Nov-2008

City: Oakland, CA 94607

Project Name:SAS SuperstructureOSM Arrival Time:2230Prime Contractor:American Bridge/Fluor Enterprises, a JVOSM Departure Time:730

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Location: Shanghai, China

**CWI Name: CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Oualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A **Approved Drawings:** Yes No N/A **Approved WPS:** Yes No Yes N/A **Delayed / Cancelled:** No

Bridge No: 34-0006 Component: OBG

### **Summary of Items Observed:**

OBG

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

ItemDescriptionWBSDwg No.Status1OBG Bottom PlateNANAQA-MT

Bay 4: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001464 (Green Tag). The subassembly is identified as OBG bottom plate BP177-001, welds 037, 040, 044, 048, 009, 012, 014 and 017 weld cover pass. Caltrans QA inspector observed that the welds have been MT inspected and accepted by ZPMC QC. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. Caltrans QA inspector assigned inspector's lot number and date to the yellow tag attached to the assembly. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 21, 2008 for additional information.

OBG Bottom Plate
NA
NA
QA-MT
Bay 4: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness

inspection, document number 001471. The subassemblies are identified as floor beams FB014-026, FB014-021, FB014-020, FB005-026, FB004-026 and FB005-028, welds FB014-026-024, 029, 033, 038; FB014-021-008, 009, 016, 017; FB014-020-024, 025, 030, 034; FB005-026-004, 008, 012, 017; FB004-026-003, 009, 013, 017 and FB005-028-024, 028, 037, 038 weld cover pass. QA inspector observed that the welds have been MT inspected and identified as accepted by ZPMC QC. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be

# WELDING INSPECTION REPORT

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in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, November 21, 2008 for additional information.

3 Tower Diaphragm Flange NA

NA

ZPMC QC-MT

**OBG** 

Bay 8: ZPMC notification of witness inspection, document number 001466 was presented to Caltrans QA for magnetic particle test (MT) inspection; tower diaphragm flange welds identified as NSD1-SA362-13 & 14, SSD1-SA361-15 & 16, ESD1-SA399-1 & 2 and ESD1-SA422-1 & 2. Caltrans QA observed that ZPMC has not MT inspected the welds.

4 Orthrotropic Bridge Girder NA

NA

Welding

**OBG** 

Assembly Building: Caltrans QA inspector arrived at the Assembly at approximately 0020 hours. Caltrans QA inspector observed that no work was being performed orthotropic bridge girder assemblies.

## **Summary of Conversations:**

s identified within the contents of this report.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, 150-0219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer